

Date: Friday, 11/18/2005 5:41:27 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 24893	
Estimate Number : 10035	
P.O. Number : N/A	Part Number : D6101007
This Issue : 11/18/2005 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24070	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/20/2005 Qty: 100 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 154

a) Description: Aluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

05-12-23

100

2.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)
 7075-T7351 2X6X6.25

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

05-12-22

62
100

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

06/01/12

62

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
dd/mm/yy	#	Change step 4 & 5 in front of step step 4						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:41:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 24893

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *cell*

50 06/01/12 62

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/01/17 62 *62* *06/01/17* *62*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	:	0024893	Department Code:	
Project Name	:	D6101-007	Burden Flags	: NNNNNNN
Project For	:	WK602	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D6101-007	Invoice Number	:
Description	:	7075-T7351 8.25X7.75X2.5	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	100	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	01-15-06	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



1, Zavodskaya Str.
347045 Belaya Kalitva
Rostov region Russia

OAO «Belaya Kalitva Metallurgical Products Company»

INSPECTION CERTIFICATE

EN 10204-3.1B

№ 7053
Date 10.08.

TOMER
Köfem Kft.
1-15
esfeher
3000
Hungary

CONTRACT № 643/54044146/002

APPENDIX № 12727

ORDER №

Description of Goods Aluminium Plates

Alloy and Temper 7075 T 651

Lot № 70458

Standard ASTM B209-02a, ANSI -H35.2-01, AMS-QQ-A-250/1,
AMS 4045H

Dimension 2,0300*60,500*144,500

Net Weight 846 kg Qt. of packages _____ pcs

CONSIGNEE
DIVERSIFIED INDUSTRIAL PROD
40 SKYLINE DRIVE
PLAINVIEW, NY 11803

MECHANICAL PROPERTIES		Ultimate Strength	Yield Strength	Elongation
Units		KSi	KSi	Elt %
Nominal requirements	min	77,0	67,0	6
	max			
Test results		78,3-79,3	68,1-68,8	9,6-11,3

DIVERSIFIED INDUSTRIAL PRODUCTS CORP.
CERTIFY THIS A TRUE COPY OF THE
MILL TEST REPORT USED TO FILL YOUR
ORDER.

Company DART AEROSPACE LTD.
PO# 00 000 154
Our Inv. # 27657
Qty. 96 EA.
Part # _____

QC Dept. Cathi Vail
Cathi Vail

ITEM # 2
* STARTING MATERIAL *

CHEMICAL COMPOSITION, %

		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
ninal ements	min			1,2		2,1	0,18		5,1	
	max	0,40	0,50	2,0	0,3	2,9	0,28		6,1	0,2
ults	4-998	0,08	0,30	1,61	0,08	2,55	0,21		5,87	0,06

hereby certified that the above material is manufactured in
pliance with the specified standards and meets the stipulated requirements

Quality Control Inspector



Форма ОГТ.058/01

ORDER.
WILL TEST REPORT USED TO FILL YOUR
CERTIFY THIS A TRUE COPY OF THE
DIVERSIFIED INDUSTRIAL PRODUCTS CORP.

CC Dept. _____
Part # _____
Op. _____
Our Inv. # _____
PO# _____
Company _____
CASH VAIL



1. Zavodskaya Str.
347045 Belaya Kalitva
Rostov region Russia

OAO «Belaya Kalitva Metallurgical Products Company»

INSPECTION CERTIFICATE

EN 10204-3.1B

№ 5749
Date 23.06

TOMER
coa-Köferm Kft.
eci u. 1-15
esfehervar
8000
Hungary

CONSIGNEE
DIVERSIFIED INDUSTRIAL PROD.
40 SKYLINE DRIVE
PLAINVIEW, NY 11803

CONTRACT № 643/54044146/002

APPENDIX № 12727

ORDER №

Description of Goods Aluminium Plates

Alloy and Temper 7075 T 651

Lot № 70463

Standard ASTM B209-02a, ANSI -H35.2-01, AMS-QQ-A-250/1
AMS 4045H

Dimension 2,0300*60,500*144,500

Net Weight 1706 kg Qt. of packages _____ pcs

MECHANICAL PROPERTIES		Ultimate Strength	Yield Strength	Elongation
Units		KSi	KSi	Elt %
Nominal requirements	min	76,0	64,0	5
	max			
Test results		77,4-79,1	66,2-69,3	5,0-10,4

CHEMICAL COMPOSITION, %

		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
Final elements	min			1,2		2,1	0,18		5,1	
	max	0,40	0,50	2,0	0,3	2,9	0,28		6,1	0,2
4-994		0,10	0,31	1,62	0,09	2,48	0,21		5,85	0,055

DIVERSIFIED INDUSTRIAL PRODUCTS CORP.
CERTIFY THIS A TRUE COPY OF THE
MILL TEST REPORT USED TO FILL YOUR
ORDER.

Company DAAT AEROSPACE LTD.

PO# 00000154

Our Inv. # 27657

Qty. 4 EA.

Part # _____

QC Dept. Cathi Vail

Cathi Vail

* STARTING ITEM # 2 MATERIAL *

hereby certified that the above material is manufactured in
compliance with the specified standards and meets the stipulated requirements

Quality Control Inspector



Форма ОТТ.058/01

DIVERSIFIED INDUSTRIAL PRODUCTS CORP.
CERTIFY THIS A TRUE COPY OF THE
MILL TEST REPORT USED TO FILL YOUR
ORDER.

Carlin Vail
Carlin Vail

Burton Industries, Inc.

243 Wyandanch Avenue North Babylon, NY 11704 (631) 643-6660 FAX (631) 643-6665

Serving the Heat Treating Industry since 1971

Certificate of Compliance

Diversified Industrial Prod. Corp.

40 Skyline Drive

Plainview, NY 11803

(516) 822 - 8300 FAX (516) 822 - 8332

Ref. No: 129817

Issued: 12/20/2005

Material: 7075-T651		Cond. Req'd. T7351		Spec.			
Quantity	Part Number			Purchase Order			
100	6.00 X 6.25 X 2.00" THK			22475			
100	7.875 X 6.25 X 2.00" THK						
100	5.00 X 6.25 X 2.50" THK						
100	7.75 X 8.25 X 2.50" THK						
Process Performed		Date	Temp (F)	Time	Atmosphere	Furnace	Hardness
ARTIFICIAL AGE		12/17/2005	325	26 HRS	AIR	260	
HRB							80-83
Condition	T7351	Tested	40	Passed	40	Reject	0
Conductivity	39.5-41.1 % IACS	Tested	400	Passed	400	Reject	0

We hereby certify that the articles stipulated above have been processed in conformance with all applicable specifications, drawings, and/or written instructions. Test and/or Inspection Reports indicating conformance are on file for examination

Nancy Mase



Nancy Mase

Q.A. Administrator
Burton Industries, Inc.



"Building a Stronger Future"

<http://www.heatreat.com>

AS 9100A Compliant



V050405R2A 129806



40 Skyline Drive, Plainview, NY 11803 Tel: 516.822.8300 Fax: 516.822.8332

Customer PO #	Order Date	SP
00000154	11/23/05	JP

Sales Order Number	5465
Invoice Date	12/21/2005
Invoice Number	27657

Ship To:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

# Pkg.	4 SKIDS
Weight	4590 LBS

Terms	Ship Date	Shipped Via	Freight	FOB	Test Reports
50% CIA/BAL N...	12/21/2005	THROWBRIDGE ...	COLLECT	ORIGIN	Y

Item No.	Orig. Qty	Unit	Description	Bal. on Order	Qty This Shipment
1	100	EA	7075-T7351 QQ-A-250/12 6.00" X 6.25" X 2.00" THK (GRAIN ALONG 6" DIM)		100
2	100	EA	7075-T7351 QQ-A-250/12 7.875" X 6.25" X 2.00" THK. (GRAIN ALONG 7.875 DIM)		100
3	100	EA	7075-T7351 QQ-A-250/12 5.00" X 6.25" X 2.50" THK (GRAIN ALONG 5" DIM)		100
4	100	EA	7075-T7351 QQ-A-250/12 7.75" X 8.25" X 2.50" THK (GRAIN ALONG 7.75" DIM)		100
			CUT TOLERANCE ON ALL IS +.063/-00		

PACKING LIST

CERTIFICATE OF COMPLIANCE

We certify that the materials described above conform to the specifications stated.

Cathie Vail

Quality Control Manager